

Order 12601



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D5669-041

Job Sheet 188992



Part No: D5669-041

Job Qty: 1 ea

Part Name: Long Basket Lid Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/17/19

Job Tracking No:

Due Date: 2/14/19

Created By: Dara Macdonald

Type: SOLD

Description:

Note: TBD DWG D5669 REV.A IPP REV:A 18.07.23 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/14/19	0.00	0.00	Start Up Large Fab-5		<i>EPC</i>
100	Large Fab	1		2/14/19	0.00	6.67	Large Fab 1		<i>EPC</i>
		pcs							
110	QC	1		2/14/19	0.00	0.00	QC9		<i>JS</i>
		pcs							
120	QC	1		2/14/19	0.00	0.00	QC5		<i>JS</i>
		pcs							
130	Powdercoat - 4 Black Sand - B4B	1		2/14/19	0.00	0.40	Powdercoat - 1 - B4B		<i>BL 19-01-31</i>
		pcs					Powdercoat - 2 - B4B		
							Powdercoat - 3 - B4B		
							Powdercoat - 4 - B4B		
135	QC	1		2/14/19	0.00	0.00	QC3		<i>DAS 19-02-12</i>
		pcs							
140	HandFinish	1		2/14/19	0.00	0.80	HandFinish4		<i>BE 19-02-12</i>
		pcs							
150	QC	1		2/14/19	0.00	0.00	QC5		<i>AK 19-2-12</i>
		pcs							
160	Packaging	1		2/14/19	0.00	0.00	Packaging3-2		<i>BE 19-02-12</i>
		pcs							
170	QC21-SA	1 Ea		2/14/19	0.00	0.00	QC21		<i>21 FEB 12 2019</i>

Part Op 100 - 1- Assemble ribs , weld as per dwg D5669 using DT9607A 2- Weld hinge (3) and Mounting brackets as per dwg
 Descriptions: D3914 ***Visual inspect before welding mesh*** 3- Cut lid mesh as per dwg 4- Tack weld mesh on basket as per dwg
 D5669 ***Cut out mesh where label plate goes in center off basket lid as per dwg. Make sure to place mesh correctly on
 lid, check with label plate before tacking mesh*** **CUT OUT MESH ON TOP OF D2581 1.5" HIGH*** **DOUBLE
 CHECK WITH A HANDLE*** 5- ****SCRIBE ID AS PER DWG NOTE 6 ON SHEET 1****
 120 - ****SCRIBE ID AS PER DWG NOTE 6 ON SHEET 1****
 130 - *** Mask holes as per note 9, sides of hinge and note 11 prior to powdercoat*** START TIME: *10:30* OVEN
 TEMPERATURE: *375°* FINISH TIME: *10:45* *M138997*
 140 - 1- Assemble as per dwg 2- Mask data plate and apply wing walk on outside surface of mesh as per dwg and QSI
 Wing Walk batch: _____

007749

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	90-Start up Operation	5143 339
D3914-1	Rib	2 pcs (2 ea)	90-Start up Operation	5140 403
D4016-3	Hinge Half, Lid	3 pcs (3 ea)	90-Start up Operation	5110 937
D4035-043	Lid Rib Assembly, Aft (350 Basket)	2 pcs (2 ea)	90-Start up Operation	5145 630
D5670-1	Rib	4 pcs (4 ea)	90-Start up Operation	5131 279
D5670-3	Rib	9 pcs (9 ea)	90-Start up Operation	5145 898
D5672-1	Data Plate	1 pcs (1 ea)	90-Start up Operation	5133 197
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	90-Start up Operation	5125 258
AN3-14A	Bolt	4 Ea (4 ea)	140-HandFinish	5112 900
AN3-16A	Bolt	2 Ea (2 ea)	140-HandFinish	5089 276
AN5-17A	Bolt	2 Ea (2 ea)	140-HandFinish	5143 682
D2530	Handle Weldment	1 pcs (1 ea)	140-HandFinish	5152 273
D2535	Spring	2 pcs (2 ea)	140-HandFinish	5147 273
D2537	Bushing	2 pcs (2 ea)	140-HandFinish	5123 161
D3953-17	Gas Spring Spacer	2 pcs (2 ea)	140-HandFinish	5135 367
D3953-19	Gas Spring Bracket	2 pcs (2 ea)	140-HandFinish	5143 335
MS21042L3	Nut	6 Ea (6 ea)	140-HandFinish	5094 592
MS21042L5	Nut	2 Ea (2 ea)	140-HandFinish	5142 139
NAS1149F0332P	Washer	8 Ea (8 ea)	140-HandFinish	5134 693-1
NAS1149F0563P	Washer	2 Ea (2 ea)	140-HandFinish	5080 31-3

M.U. 008060

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	61	0
	D3914-1	2	12	0
	D4016-3	3	171	0
	D4035-043	2	14	0
	D5670-1	4	4	0
	D5670-3	9	0	0
	D5672-1	1	8	0
	M304EX0.75-16F	32	1,292	0
	AN3-14A	4	275	0
140-HandFinish	AN3-16A	2	45	0
	AN5-17A	2	129	0
	D2530	1	5	0
	D2535	2	19	0
	D2537	2	0	0
	D3953-17	2	27	0
	D3953-19	2	50	0
	MS21042L3	6	2,207	0
	MS21042L5	2	294	0
	NAS1149F0332P	8	2,259	0
	NAS1149F0563P	2	544	0

Part Specifications

Specifications could not be found.

Plav 1/17/19 10:49 AM Dart.Macdonald.Dara



Container No: S148192



Part: D5669 - 041

Job No: 188992

Serial No/Batch: S148192

Revision: A

Inspector:

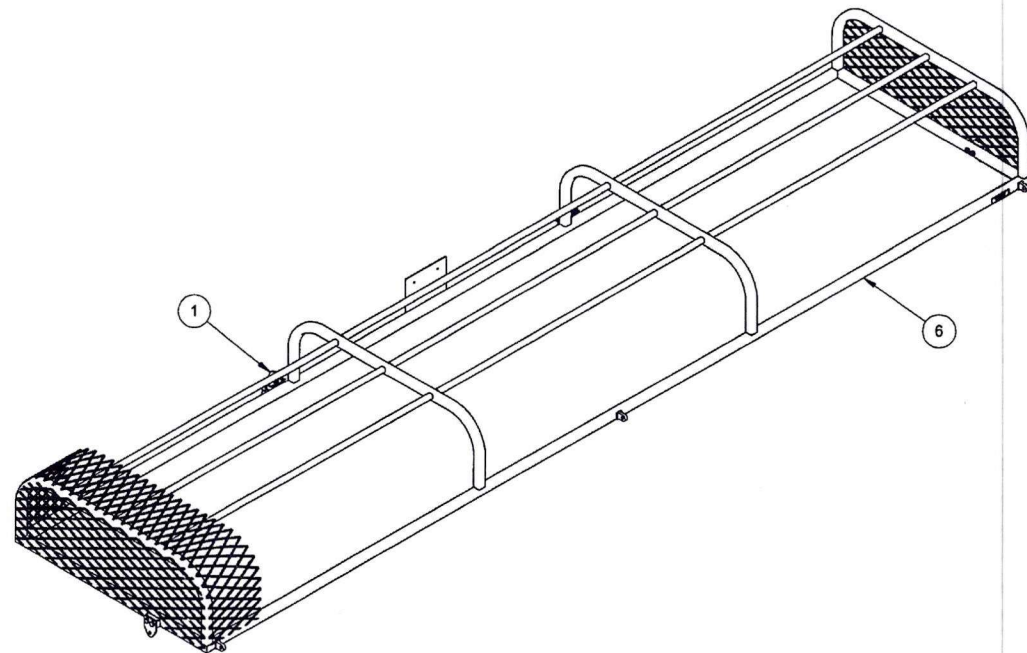
Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 01/25/19

ITEM	QTY. -041	P/N	DESCRIPTION
	X	D5669-041	LONG BASKET LID ASSY
1	1	D2530	HANDLE WELDMENT
2	2	D2535	SPRING
3	2	D2537	BUSHING
4	2	D3953-17	GAS SPRING SPACER
5	2	D3953-19	GAS SPRING BRACKET
6	1	D5669-043	WELDMENT LID ASSY
7	2	AN3-16A	BOLT
8	4	AN3-14A	BOLT
9	2	AN5-17A	BOLT
10	6	MS21042L3	NUT, SELF-LOCKING
11	2	MS21042L5	NUT, SELF-LOCKING
12	8	NAS1149F0332P	WASHER
13	2	NAS1149F0563P	WASHER



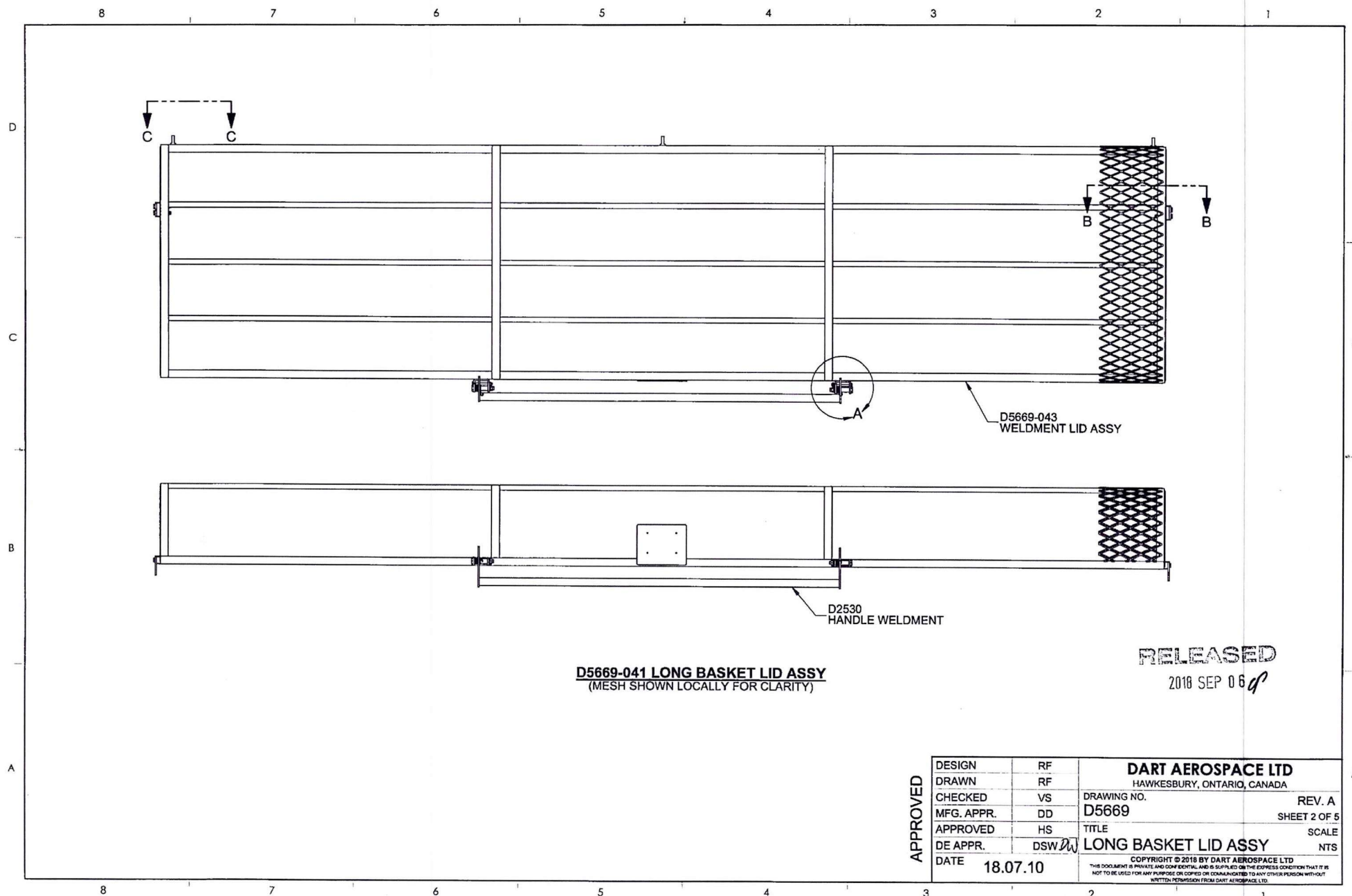
D5669-041 LONG BASKET LID ASSY
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: SCRIBE DART P/N AND S/N USING 0.13 (MINIMUM) HIGH LETTERING PER QSI 044 6.4
7) WEIGHT: 41.82 lbs APPROX

RELEASED

2018 SEP 06
ECN 18-796

A		NEW ISSUE		RF	18.07.10
REV.	DESCRIPTION			BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A SHEET 1 OF 5	
DRAWN	RF				
CHECKED	VS	DRAWING NO.		SCALE	
MFG. APPR.	DD	D5669		NTS	
APPROVED	HS	TITLE		SCALE	
DE APPR.	DSW	LONG BASKET LID ASSY		NTS	
DATE		18.07.10		COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

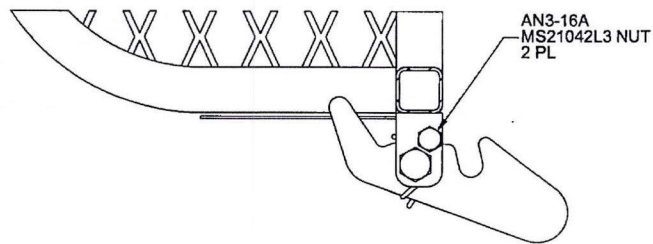


D5669-041 LONG BASKET LID ASSY
(MESH SHOWN LOCALLY FOR CLARITY)

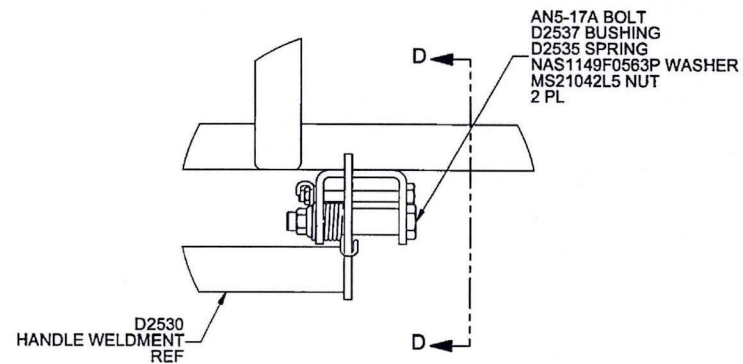
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2018 SEP 06 *dp*

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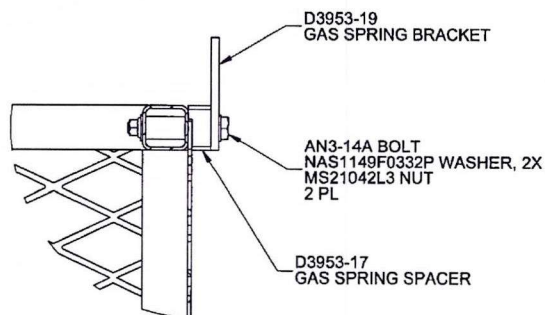
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	DD	D5669	SHEET 2 OF 5
APPROVED	HS	TITLE	SCALE
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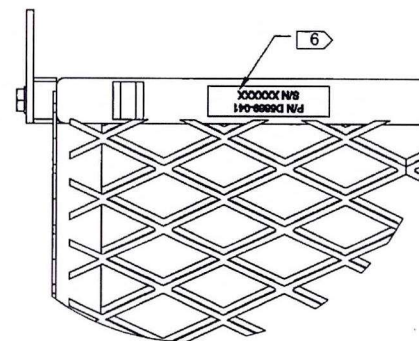
SECTION D-D
SCALE 2X



DETAIL A
SCALE 2X
2 PL



SECTION B-B
SCALE 2X
2 PL



VIEW C-C
SCALE 2X

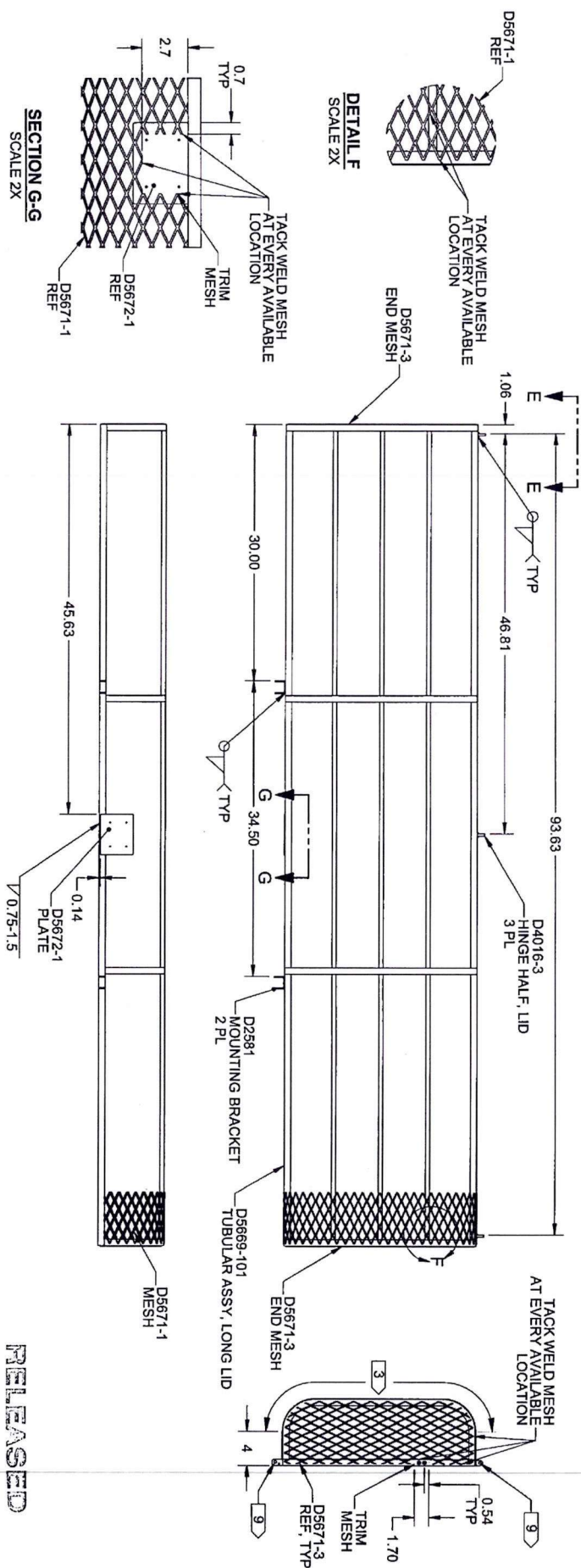
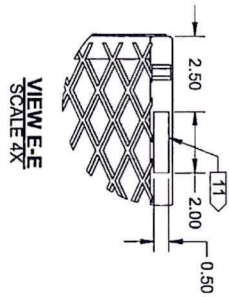
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2018 SEP 06

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MFG. APPR.	DD	D5669	SHEET 3 OF 5
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DE APPR.	DSW	LONG BASKET LID ASSY	NTS
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ITEM	QTY.	P/N	DESCRIPTION
	X	D5669-043	WELDMENT LID ASSY
1	2	D2581	MOUNTING BRACKET
2	3	DA016-3	HINGE HALF, LID
3	1	D5669-101	TUBULAR ASSY, LONG LID
4	1	D5671-1	MESH
5	2	D5671-3	END MESH
6	1	D5672-1	PLATE



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART OSI 005 4.3
 - 3) ANTI-SKID: APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART OSI 005 4.4
 - 4) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: N/A
 - 8) WEIGHT: 36.37 lbs APPROX
 - 9) MASK HOLES PRIOR TO FINISHING
 - 10) WELD PER DART OSI 004
 - 11) MASK THIS AREA PRIOR TO FINISH

D5669-043 WELDMENT LID ASSY
(MESH SHOWN LOCALLY FOR CLARITY)

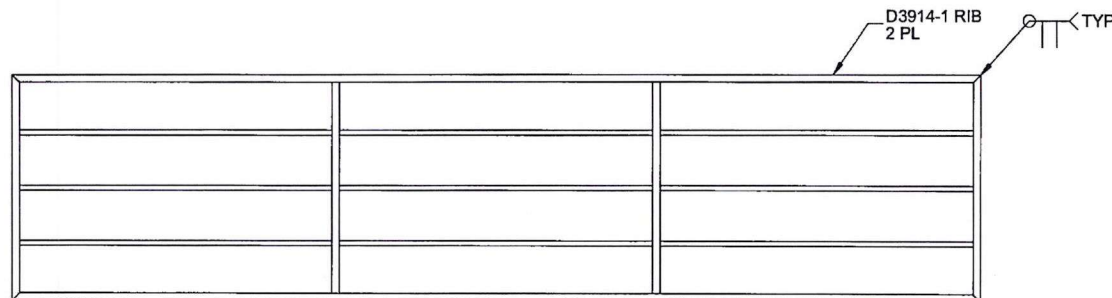
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DESIGN	RF	RF	DART AEROSPACE LTD
DRAWN	VS	VS	HAWKESBURY, ONTARIO, CANADA
CHECKED	VS	VS	
MFG. APPR.	DD	DD	D5669
APPROVED	HS	HS	REV. A
DE APPR.	DSW	DSW	SHEET 4 OF 5
DATE	18.07.10		SCALE
			NTS
			LONG BASKET LID ASSY

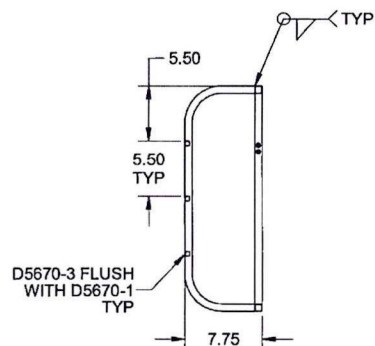
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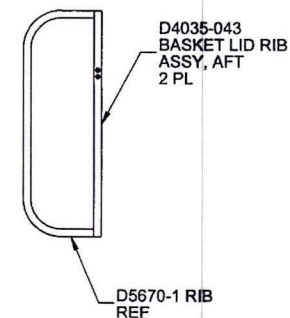
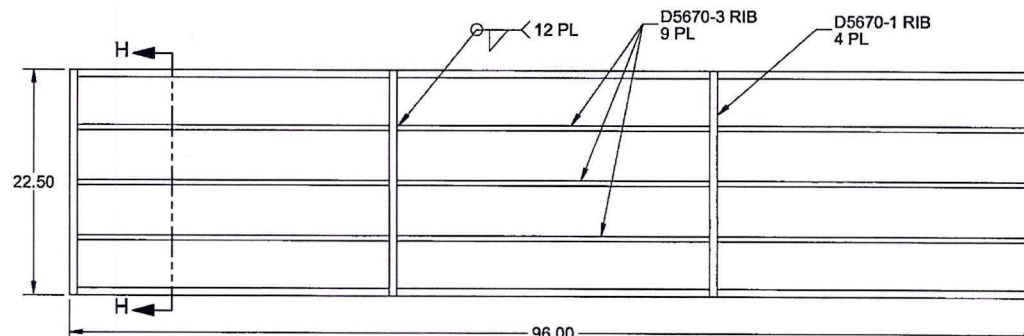
ITEM	QTY -101	P/N	DESCRIPTION
	X	D5669-101	TUBULAR ASSY, LONG LID
1	2	D3914-1	RIB
2	2	D4035-043	BASKET LID RIB ASSY, AFT
3	4	D5670-1	RIB
4	9	D5670-3	RIB



VIEW I-I



SECTION H-H



RELEASED

2018 SEP 06

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 19.49 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D5669-101
 - 9) WELD PER DART QSI 004

D5669-101 TUBULAR ASSY, LONG LID

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	DD	D5669	SHEET 5 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DSW	LONG BASKET LID ASSY	NTS
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					